

Work Order ID 117036

\*117036\*

Page 1

April-24-14 9:09:17 AM

Item ID: D3564-9 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID:  
Item Name: Stainless Steel Wearplate Fwd Stop \*NS2\*  
Start Date: 4/23/14 Start Qty: 12.00 \*12\* Cust Item ID:  
Required Date: 4/23/14 Req'd Qty: 12.00 \*12\* Customer:

Reference:

Approvals: Process Plan: ML5 Date: 1404-28 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3564	Rev D								

100 0.00

\*100\* FLOW WATER JET 12 0 Jm14-05-1  
Waterjet Memo 0.00  
FLOW CNC Waterjet 1-Cut as per Dwg D3564 \*\*\*\*\* (D3564-1F) \*\*\*\*\* Dwg Rev: D Prog  
304.06.3 Rev: D 2-Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00

\*110\* QC Memo 0.00 Jm14-05-1  
Quality Control

120 QC8- Inspect parts - second check 0.00

\*120\* QC Memo 0.00 M/5/2 Jm14 14/05/02  
Quality Control

DAS  
27  
0-29

DQA:

Date:



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only 

Work Order: _____			<b>DISPOSITION</b>		<b>AGAINST DEPARTMENT/PROCESS</b>						
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>				Engineering <input type="checkbox"/>	
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>				Quality <input type="checkbox"/>	
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved											
FAULT CATEGORY											
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function			<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence			<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge			<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

**Work Order ID 117036**

April-24-14 9:09:17 AM

**\*117036\***

Page 2

Item ID: D3564-9

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Stainless Steel Wearplate Fwd

Stop

**\*NS2\***

Start Date: 4/23/14 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 4/23/14 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Brake NC	NC BRAKE	0.00							14605/05
	Memo	0.00	DAS	30	9-89	12			
	Deburr if necessaryForm on Brake as per Dwg D3564 using Jigs DT 8129 and DT 8155Form Joggle as per Dwg D3564 on brake using Jig DT 8157								
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00	DAS 27 p-39			12			
	Memo	0.00	MIS						
	Ensure joggle as per dwg D3429								
150 <b>*150*</b> Large Fab	Large Fab	0.00				9	14-05-13	MAL	
	Memo	0.00							
	Qty Description Batch A/R 2059B Hardcoat								
	M 107737 Weld hardcoat as per Dwg D3564								

PTO →

DOA:

✓

Date: 14/06/03



## **WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed:

Date: 14/5/22

## Work Order update only

Work Order: <u>117036</u>	<b>DISPOSITION</b>	<b>AGAINST DEPARTMENT/PROCESS</b>					
Part No. <u>D3564-9</u>	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input checked="" type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. <u>14-3888</u>	Scrap <input checked="" type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input checked="" type="checkbox"/>		
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			

**FAULT CATEGORY**

Landing Gear	General			
Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	<input checked="" type="checkbox"/> Wrong Stock Pulled
Crushing	Countersink	Misaligned/off center	Positioned Wrong	
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge	<input checked="" type="checkbox"/> Other
Inspection Strip in Tube	Drawing	Misread		
Marks/Chatter	Drill Holes	Off-set		
Turning Sequence	Finish	Out of Calibration		
Wave/Twist in Tube	Fit/Function	Out of Sequence		

Work Order ID 117036

April-24-14 9:09:17 AM

\*117036\*

Page 3

Item ID: D3564-9

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Stainless Steel Wearplate Fwd

Stop

\*NS2\*

Start Date: 4/23/14 Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 4/23/14 Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

(Q)

14-05-13

DAS

9

9-89

\*160\*

QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

(Q)

14-05-13

DAS

9

9-89

\*170\*

QC

Memo

0.00

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

(Q)

9 φ 445-16

DAS

9

9-89

\*180\*

Powdercoat

Powder Coating

Memo

0.00

START TIME:

9:05

OVEN TEMPERATURE:

FINISH TIME:

9:35

DQA:

Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: \_\_\_\_\_

Work Order update only 

Work Order: _____			<b>DISPOSITION</b>			<b>AGAINST DEPARTMENT/PROCESS</b>							
Part No. _____			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>						
NCR No. _____			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>						
Suspected Unapproved <input type="checkbox"/>			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>						
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector		
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved													
FAULT CATEGORY													
Landing Gear	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence Wave/Twist in Tube			General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish Fit/Function			Folio/Program Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Mislabeled Misread Off-set Out of Calibration Out of Sequence			Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other	

Work Order ID 117036

\*117036\*

Page 4

April-24-14 9:09:17 AM

Item ID: D3564-9

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Stainless Steel Wearplate Fwd

Stop

\*NS2\*

Start Date: 4/23/14 Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 4/23/14 Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC3- Inspect Part Finish

0.00

27

9.89

0.00

14/5/16

9

\*190\*

QC

Quality Control

200

Identify as per dwg & Stock Location:

FP-002

0.00

\*200\*

Packaging

Packaging

Memo

0.00

x9 6/16 w/05/20

210

QC21- Final Inspection - Work Order Release

0.00

\*210\*

QC

Quality Control

Memo

0.00

14/5/20 JJ  
MF 14/5/20

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: \_\_\_\_\_

Work Order update only 

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
			Suspected <input type="checkbox"/>	Unapproved <input type="checkbox"/>		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
						Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
						Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>							
Centre Not Concentric	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>							
Cracks	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>							
Crimp/Kink/Ripple/Wave	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>							
Cuffs	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>							
Crushing	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>								
Heat Treat	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>							
Inspection Strip in Tube	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>									
Marks/Chatter	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>									
Turning Sequence	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>									
Wave/Twist in Tube	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>									

# Picklist Print

Page 1

April-24-14 9:09:19 AM

Work Order ID: 117036

\*117036\*  
\*D3564-9\*

Parent Item: D3564-9

Parent Item Name: Stainless Steel Wearplate Fwd

Start Date: 4/23/14

Required Date: 4/23/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-03-08 ec  
IPP Rev:B As per Rev C 07-07-09 JLM  
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	123.2670	1.41	18		**	JM14-05-1

\*M304S16GA\*

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT020	123.267	
M126915	0.737	
M127821	122.53	127821

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only 

Work Order: _____		DISPOSITION			AGAINST DEPARTMENT/PROCESS														
Part No. _____		Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Machining <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/>	Quality <input type="checkbox"/>	Other <input type="checkbox"/>
NCR No. _____	Suspected Unapproved <input type="checkbox"/>																		
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description			Sign & Date	Verification			QC Inspector					
Design																			
Doc/Data																			
Equip/Tooling																			
Handling/Pre																			
Material																			
Operator																			
Offset/Setup																			
Process																			
Supplier																			
Training																			
Transport																			
Unapproved																			
FAULT CATEGORY																			
Landing Gear				General															
Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced															
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up															
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure															
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld															
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled															
Crushing	Countersink	Misaligned/off center	Positioned Wrong																
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge	Other															
Inspection Strip in Tube	Drawing	Misread																	
Marks/Chatter	Drill Holes	Off-set																	
Turning Sequence	Finish	Out of Calibration																	
Wave/Twist in Tube	Fit/Function	Out of Sequence																	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	117036
<b>Description:</b> Wearshoe	<b>Part Number:</b>	D3564-9
<b>Inspection Dwg:</b> D3564 <b>Rev:</b> D		<b>Page 1 of 1</b>

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

DAS	
Measured by:	Jm
Date:	14-05-1

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	08.01.16	New Issue	KJ/EC/DD	





